April-11-13 11:16:42-AM

\*99549\*

Item ID: Revision ID:	D2236			Accept	100	)* s	etup Star	* <b>*</b> N	S1*		
Item Name:	Lid Rib				,			•	Stop	*N.	S2*
Start Date:	4/11/13	Start Qty: 16.0	° *16	Q[],[,)(p(	Cust Item II	<b>)</b> :				•	
Required Date:	4/18/13	Req'd Qty: 16.0	° *167	$\mathcal{O}(17X)^{+}$	Customer:			-			
Reference:											
Approvals:	Process Pl	an: MLJ	Date: 13-04-	/_ Tooling:	Dat	te:	- 	F		^ <b> V</b>	R1*
	QC:	- A	Date:	SPC (Y/N):	Da	te:			Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr					7				+
D2236	C						. *		_		
100				0.00							<del></del>
*100*		Large Fab						(C)	271	\\ D	D
Large Fab		Memo		0.00				-0	D-04-		
Large Fab		1- Pick D	3166-3 and cut use DT8303	3				6x	13-0	4-12	DI
		2- Remov	e identification markings o	n tube	- -				Stop	, , ,	
		3- Deburr								٠	
110		QC6- Inspect dimensi	ons to drawing	0.00	3.4.15			ı <b>1</b>			
*110* QC Quality Control		Memo		0.00	,,,,,		,	<u> </u>	-10		

													DQA:	Da	ite:			
NCR:	⁄es	/ No					WORK ORDER NON-C	01	NFORM	MANCE / UPI	DATE		QA Closed:		ıte:			
<del></del> :						1	DISPOSITION	-	AGAINST DEPARTMENT/PROCESS									
Nork Orde	er:						DISPOSITION	_			AGAINST	<u> </u>	- -	/PROCESS				
	Part No.  NCR No.  Root Cause Date Step Qty  Data p/Tooling er ator serial up er cess plier ning pproved  Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube					Rework Skid-tube Crosstube  Scrap Machining Small Fab  Use-as-is Thermoforming Finishing  Work Order Update Large Fab Composite					-	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other				
Root					Desc	rip	tion of work order update	П	Initial	Act	tion		Sign &					
Cause		Date	Step	Qty		•	r Non-conformance	Ch	nief Eng	Descr	ription		Date	Verification		QC Inspector		
oc/Data quip/Tooling perator faterial etup other rocess upplier raining napproved										·								
							F	AUL	LT CATE	GORY								
Landi	ng (	Gear			_		General	_	_		-		•		_	•		
		Centre Not Concentric to O/S				Bend BOM/Route Broken/Damaged		-	on incomplete		Ovalized Over/Under tolerance Part Incorrect				Pressure/Forced Temperature/Cure Weld			
			Crimped		}		Burrs Contamination	$\vdash$	Instruct	ions Incomplete/Unance	Unclear		Part Lost/Mi Part Moved	issing	<u> </u>	Wrong Stock Pulled		
		l	t		-		Countersink		Mislabe		-		Positioned V	Vrong		_		
		Inspection	n Strip in	Tube			Cut Too Short		Misread	I			Power Loss/	Surge		Other		
		Ripples in	Bend				Drill Holes		Offset		_							
		Torque W	aves in E	xtrusior	, ' [		Drawing		Out of 0	Calibration								
		Turning Se	eallence		1		Finish		Out of S	Sequence								

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

April-11-13 11:16:42 AM Item ID: D2236 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Lid Rib **Start Date: Start Qty:** 16.00 4/11/13 **Cust Item ID:** Required Date: 4/18/13 Req'd Qty: 16.00 Customer: Reference: Run Process Plan: \_\_\_\_\_ Date: \_\_\_\_ Approvals: Tooling: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp Identify as per dwg & Stock Location: WA /4 120 0.00 P(13.4.15 \*120\* Packaging , 0.00 Memo Packaging 130 QC21- Final Inspection - Work Order Release 0.00 QC 0.00 Memo Quality Control

											DQA:	: Date	:
NCR:	Yes /	No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE			
											QA Closed	: Date	•
Work Orde	or.					DISPOSITION	١			AGAINST D	EPARTMENT	PROCESS	
WOIK OIGE	<del></del>				_ <del></del>	Rework	ı		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	No ·					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	Quality
10.11					<del></del>	Use-as-is			noforming	Finishing	┥	re/Packaging	Other
NCR N	No.					Work Order Update			Large Fab	Composite	1,	Supplier	1
				· · · · · · · · · · · · · · · · · · ·			1			·			
Root					Descri	ption of work order update	I	nitial	Ac <sup>-</sup>	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш		ŀ										
Material	Ш												
Setup	Ш	1					'						
Other	Ш						ł						
Process	Ш												
Supplier													
Training	Ш										1.		
Unapproved												<u> </u>	1
							AUL	T CATE	GORY				
Landi	ng Gea				_	General		۱		_	٦	_	٦
,	$oldsymbol{oldsymbol{ ext{}}}$	nding			. –	Bend		Grain		-	Ovalized		Pressure/Forced
	$\vdash$		ot Conce	ntric to	O/S	BOM/Route	Ш	Hardwa		<u> </u>	Over/Under	<del>-</del>	Temperature/Cure
	—	acks			<u> </u>	Broken/Damaged	$\vdash$		on Incomplete		Part Incorre	<del> </del>	Weld
	$\vdash$		Crimped		<u> </u>	Burrs			ions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled
	Cu				<u> </u>	Contamination	$\vdash$	Mainte		<u> </u>	Part Moved		
	I lHe	at Trea	ıt		1	Countersink	1	Mislabe	eled	i i	Positioned \	Wrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

April-11-13 11:16:47 AM

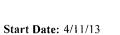
Work Order ID: 99549

Parent Item Name: Lid Rib

D2236

\*99549\*

\*D2236\*



Required Date: 4/18/13

**Start Qty: 16.00** 

Required Qty: 16.00

Com	m	en	ts
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Parent Item:

IPP REV:A 12.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	1.0387	0.25	4	<i>←</i> . (	^/	
*D3166-3*	•	•						1	**	<b>(2)</b>	18-	DN-11 DN	8D

<b>Location</b>		Loc Oty	Loc Code
WA		0.494736	
94157	-	0.494736	1
WA004		0.1052	1
81578		0.1052	!
WA007		0.4388	T.
77294		0.4388	i

										DQA:	Date	e:
NCR: Y	es / No				WORK ORDER NON-C		NFORM	AANCE / UPDA			<del></del>	-
				-						QA Closed:	Date	2:
Work Orde	eř.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIR OIGC					Rework		<u>.</u>	Skid-tube	Crosstube	•	Water Jet	Engineering
Part N	lo				Scrap		Г	Machining	Small Fab	1	d. Eng. Coor.	Quality
					Use-as-is			noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR N	lo				Work Order Update	l		Large Fab	Composite	j	Supplier	
Root				Descri	ption of work order update		nitial	Actio	n	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng Description			Date	Verification	QC Inspector
Doc/Data			r									
Equip/Tooling						Ì						
Operator								,				
Material		:										
Setup				•								
Other												
Process												
Supplier												
Training				·		l						
Unapproved											·	
					F/	AUL	T CATE	GORY				
Landir	ng Gear				General				·	•	_	_
[	Bending				Bend		Grain			Ovalized	L	Pressure/Forced
	Centre f	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct _	Weld
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/Un	ıclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	eat			Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspecti	on Strip ir	ı Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

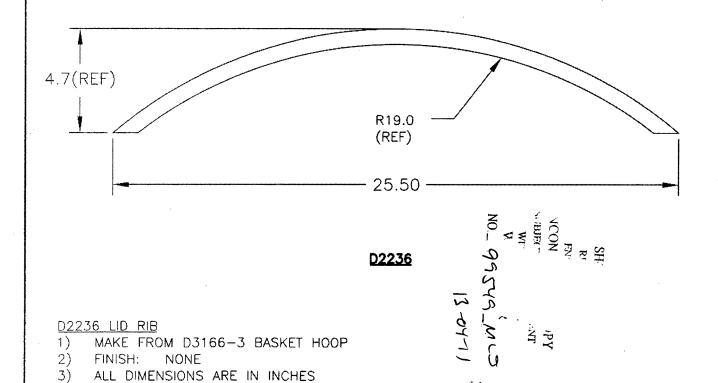
Finish

Folio



DESIG E	3M N	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA									
CHEC	KED ,	APPROVED	DRAWING NO.	REV. C								
	#	<del>       </del>	.D2236 sh	IEET 1 OF 1								
DATE			TITLE	SCALE								
05.0	06.07		LID RIB	1:4								
Α		94.05.30	NEW ISSUE									
В		94.12.16	LID									
C		05 06 07	UPDATE NOTES CHANGE RADIUS	ro 190								

RELEASE



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